

304 314

Work Order ID 147899

Friday, June 17, 2016 7:54:51 AM

147899

Page 1

Item ID: D5152-7

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Aft Step Post

Stop *NS2*

Start Date: 7/7/2016

Start Qty: 4.00

4

Required Date: 7/13/2016

Req'd Qty: 4.00

4

Cust Item ID:

Reference:

Customer:

Approvals:

Process Plan: MLS

Date: JUN 17 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D5152

B

100

100

Doosan

DOOSAN LATHE

0.00

DAS

45

9-89

Memo

0.17

21

0

2016-6-25

Doosan Lathe

1- Turn as per Folio FB

Rev: AA &

Dwg Rev: B

110

110

QC

QC2- Inspect parts off machine FAI/FAIB

0.00

DAS

45

9-89

Memo

0.01

21

0

2016-6-25

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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Work Order ID 147899

Friday, June 17, 2016 7:54:51 AM

147899

Page 2

Item ID: D5152-7

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Aft Step Post

Stop ***NS2***

Start Date: 7/7/2016 Start Qty: 4.00

4

Required Date: 7/13/2016 Req'd Qty: 4.00

4

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.01				21	0		DAS 14 9-89
Quality Control									16/06/26
150	Identify as per dwg & Stock Location: _____	0.00							
150									
Packaging	Memo	0.01							
Packaging	LOCATION: WA002								21 JUL 07 2016 DAS 6 9-89
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.07							
Quality Control									16/7/12

DAS
21
9-89 JUL 08 2016

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
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Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
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Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

Picklist Print

Friday, June 17, 2016 7:54:50 AM

Page 1

Work Order ID: 147899

147899

Parent Item: D5152-7

D5152-7

Parent Item Name: Aft Step Post

Start Date: 7/7/2016

Required Date: 7/13/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 15-01-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304RO.750		Purchased		No			f	34.1160		0.105263			

M304RO 750
304 SS Roundbar .750

Location

Loc Qty

Loc Code

MAT029

34.116

M134514

0.805

M134696

9.311

M134984

24

86

DAS
45
9-89

2016-6-25

DQA: _____ Date: _____



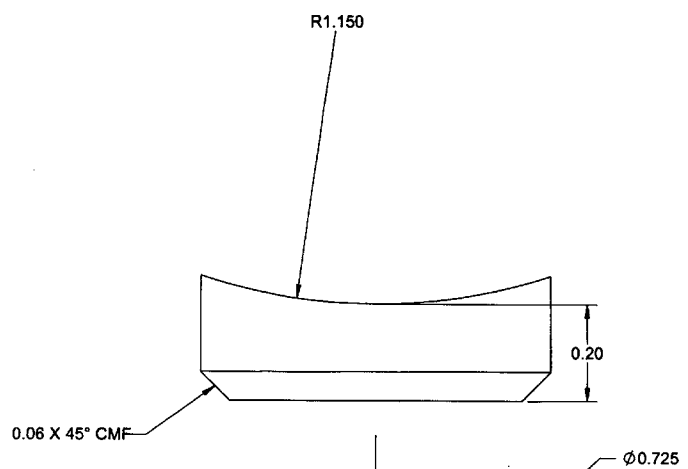
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

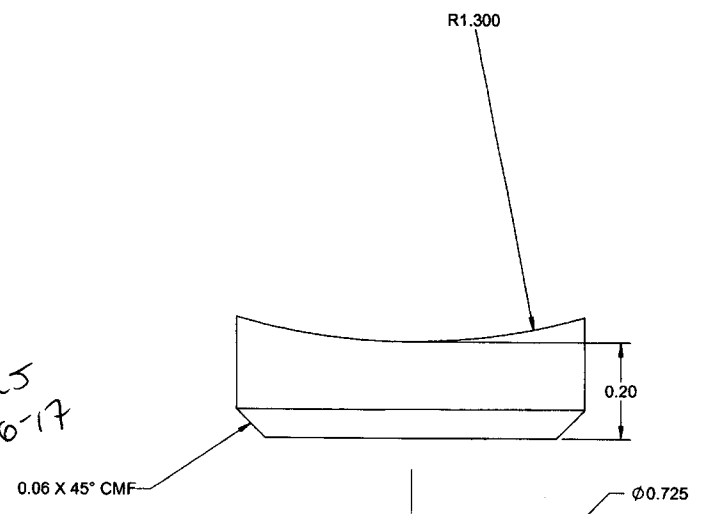
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
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Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process	OTHER :							
Misidentified ☐	☐ Past Due								

8 7 6 5 4 3 2 1



D5152-5 FWD STEP POST

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO A REVISION
WITHOUT NOTICE
WORK ORDER
NO. 147-899 MCS
1606-17



D5152-7 AFT STEP POST

RELEASED
2015 FEB 09

- NOTES:**
- 1) MATERIAL: AISI 304/316 SS ROUND BAR PER ASTM A276, REF DART SPEC M304R0.750
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.02 lbs

APPROVED	DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	EPDMA		
	CHECKED	DB	DRAWING NO.	REV. B
	MFG. APPR.	DD	D5152	SHEET 5 OF 5
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	POST MOUNT	NTS
	DATE	15.01.09	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1